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CASTING FINISHING METHOD OF CONTINUOUS CASTING FOR THIN INGOT

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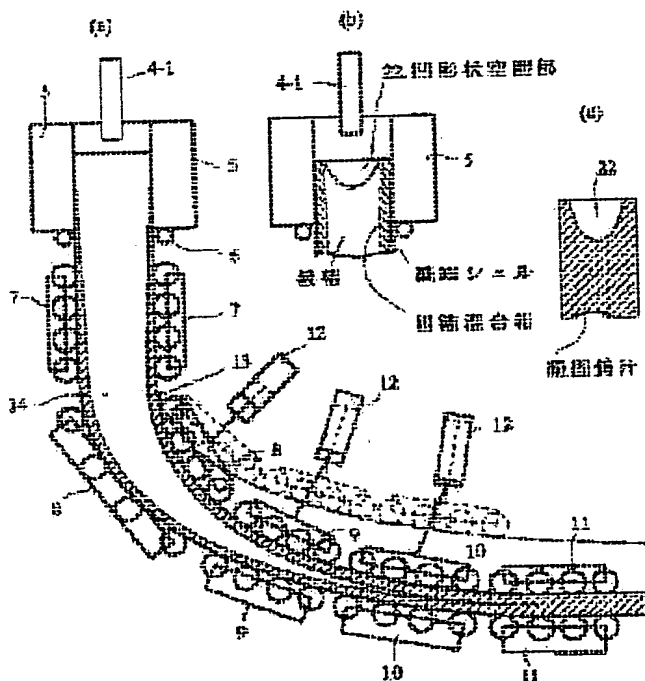
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Abstract of JP 2000288696 (A)

PROBLEM TO BE SOLVED: To prevent the generation of leaking steel without deteriorating the quality of the final end part of a thin ingot manufactured by an unsolidified rolling-down casting method. **SOLUTION:** In a casting method wherein an ingot 13 pulled out of a non-bottomed continuous casting mold 5 and having unsolidified part 14 in its inner part is rolled down in the thickness direction and the ingot thinner than the thickness of the casting mold is continuously cast, after the supply of molten steel from a tundish to the casting mold 5 is stopped, the gap between rolls in the thickness direction of the ingot of rolling reduction roll segments 8-11 is widened with a stationary casting speed maintained to cause the ingot 13 to bulge, and after the surface of the molten metal inside the casting mold is lowered, the casting speed is decreased.; Further, the gap Y between the rolls in the thickness direction of the ingot of the rolling reduction roll widened for causing bulging preferably satisfies the formula: $1.1 \times Y1 \leq Y \leq Y0$. Here, Y1 expresses the thickness of the casting mold and Y0 expresses the target thickness of the thin ingot.



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